



巨輪興有限公司

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OPERATING INSTRUCTIONS

H FRAME PRESSES



English : E1~E3

1. SAFETY PRECAUTIONS



Fail to comply with the following cautions and warnings could cause equipment damage and personal injury.



IMPORTANT : Minimum age of the operator must be 18 years The operator must have read and understood all instructions, safety issues, cautions and warnings before starting to operate the SUN RUN equipment. The operator is responsible for this activity towards other persons.



WARNING : To avoid personal injury and possible equipment damage, make sure all hydraulic components withstand the maximum pressure of 700 bar(10,000psi).



WARNING: Always wear safety glasses. The operator must take precaution against injury due to failure the tool or workpiece.



DANGER: To avoid personal injury keep hands and feet away from cylinder and workpiece during operation.



WARNING : Do not overload equipment. Overloading cause equipment failure and possible personal injury. The cylinders are designed for a max. Pressure of 700 bar (10,000psi).



WARNING: Immediately replace worn or damaged parts with genuine SUN RUN parts. SUN RUN parts are designed to fit properly and withstand rated loads.



IMPORTANT: Hydraulic equipment must only be serviced by a qualified hydraulic technician. For repair service, contact the SUN RUN Service Center in your area. To protect your warranty, use only SUN RUN oil.



DANGER: NEVER set the relief valve to a higher pressure than the maximum rated pressure of the pump. Higher settings may result in equipment damage and/ or personal injury. Do not remove relief valve.



WARNING : The system operating pressure must not exceed the pressure rating of the lowest rated component in the system. Install pressure gauges in the system to monitor operating pressure. It is your window to what is happening in the system.



CAUTION: Avoid sharp bends and kinks that will cause severe back-up pressure in hoses. Bends and kinks lead to premature hose failure.



DO NOT drop heavy objects on hose. A sharp impact may cause internal damage to hose wire strands. Applying pressure to a damaged hose may cause it to rupture.



IMPORTANT: Do not lift hydraulic equipment by the hoses or couplers. Use the carrying handle or other means of safe transport.



CAUTION : KEEP HYDRAULIC EQUIPMENT AWAY FROM FLAMES AND HEAT. Excessive heat will soften packings and seals, resulting in fluid leaks. Heat also weakens hose materials and packings. For optimum performance do not expose equipment to temperatures of 65°C(150°F) or higher. Protect hoses and cylinders from weld spatter.



DANGER: Do not handle pressurized hoses. Escaping oil under pressure can penetrate the skin causing serious injury. If oil is injected under the skin, see a doctor immediately.

2.SPECIFICATION

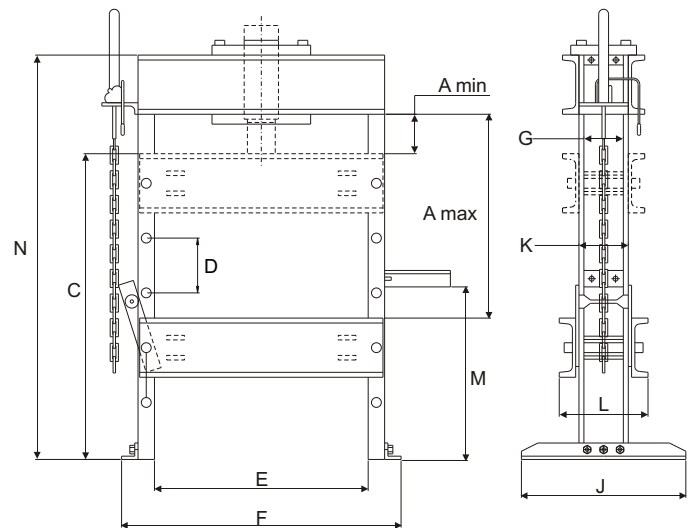
2.1 If you use air or electric pump please check the detail at first :

Air pump/ Air pressure : 7~10kgf/cm²

Electric Pump : Please check the data plate

2.2 Hydraulic oil: Aw46

Pump Model 電動泵浦型號	Motor 馬達	Oil cap. 油箱容量
SIP-10EM	0.5HP, 115V(60Hz) / 220V(50Hz),1PH	3000c.c
SIP-256EM	0.5HP, 115V(60Hz) / 220V(50Hz),1PH	3000c.c
SIP-2514EM	1HP, 115V(60Hz) / 220V(50Hz),1PH	3000c.c
SIP-30EM	1HP, 115V(60Hz) / 220V(50Hz),1PH	3000c.c
SIP-506EM	0.5HP, 115V(60Hz) / 220V(50Hz),1PH	3000c.c
SIP-5013EM	2HP, 115V(60Hz) / 220V(50Hz),1PH	5gal.
SIP-100EM	2HP, 115V(60Hz) / 220V(50Hz),3PH	5gal.
SIP-150EM	2HP, 115V(60Hz) / 220V(50Hz),3PH	5gal.
SIP-200EM	3HP, 115V(60Hz) / 220V(50Hz),3PH	5gal.



Press Model Number 壓床型號	Cap. 能力 (tons)	Model No. 油壓缸型號	Pump 泵浦	H-Frame Press Dimensions (mm) 外型尺寸											
				Vertical Daylight 工作檯面高度		C	D	E	F	G	J	K	L	M	N
				A (max)	A (min)										
SIP-RSC1010	10(101)	RSC-1010	H	1016	62	1187	127	473	632	—	756	108	189	889	1321
SIP-RSR1010		RSR-1010	A												
SIP-RSC256	25(232)	RSC-256	H	1384	178	1448	302	737	1029	102	762	133	272	673	1930
SIP-RSC2514		RSC-2514	A												
SIP-RSC308	30(295)	RSC-308	H	1384	178	1448	302	737	1029	102	762	133	272	673	1930
SIP-RSR3014		RSR-3014	A												
SIP-RSC506	50(498)	RSC-506	H	1233	179	1372	264	730	1086	127	914	184	365	781	1930
SIP-RSC5013		RSC-5013	A												
SIP-RSR5013		RSR-5013	E												
SIP-RSC10010	100(933)	RSC-10010	H	1080	178	1295	297	889	1295	171	914	222	441	842	1930
SIP-RSR1006		RSR-1006	A												
SIP-RSR10013		RSR-10013	E												
SIP-RSR15013	150(1386)	RSR-15013	E	1232	318	1384	254	1219	1706	232	1118	333	555	1213	2286
SIP-RSR20013	200(1995)	RSR-20013	E	1232	318	1384	254	1219	1706	232	1118	333	555	1213	2286

H : 手動 Hand Pumps A : 氣動 Air Hydraulic Pumps E : 電動 Electric Pumps

3. OPERATING

3.1 Bolster Adjustment:

A winch and cable assembly support the bolster when the support pins are not in place.

The following rules must be observed to prevent personal injury:

1. Keep hands, feet, etc. Out from under the bolster. Accidental slippage can result in personal injury.
2. To prevent slippage, all bolster support pins must be in place, and all cables slack, before placing a work piece on the press bed or starting a pressing operation.
3. To prevent cable breakage, never raise or lower the bolster while it holds a load.
4. When raising or lowering the bolster, remove the work the work piece. Insert a support pin all the way through the front and back uprights in the highest hole under the bolster that will not interfere with the new bolster position. Remove your hands from the support pins after the pins are in place to avoid personal injury should the bolster fall.
5. Inspect the entire length of the lifting cables at least every three months. Replace any cable that appears frayed, worn, or crushed. The cables must run on the pulleys easily, and the pulleys must be free to turn. Careful cable maintenance will help prevent cable breakage.

3.2 Assembly:

Remove banding from the press and shipping pallet, and remove all cartons. Stand the press upright. Refer to the part list, and follow these instructions during the assembly of hydraulic components and accessories.

1. Place the pump on the bracket. Thread four machine screws through the bracket into the bottom of the pump reservoir.
2. Clean the threads on the threads on the hydraulic hose(s) and in the fittings. Assemble the hose(s) to the pump.
3. Thread the other end of the hose(s) into the swivel fitting(s) on the ram.
4. Air can accumulate in the hydraulic system during initial setup or after prolonged use, causing the ram to respond slowly or in an unstable manner. To remove the air, lay the ram on the floor. Extend and retract the ram several times without putting a load on the system. Air will be released through the pump reservoir.
5. Positioning the work bed:
 - A. Put a small amount of tension on the cable by cranking the winch up, taking weight off the pins. This frees the pins in the end of the bolster next to the winch (or right side of the press). Pull the loose pins out.
 - B. Raise the other end of the bolster by pulling slightly on the handle until the other two pins are free.
 - C. Crank the winch for either up or down movement of the work bed. Reassemble the pins.

IMPORTANT:

The winch has a special friction brake for holding the bolster during positioning . The friction brake is NOT designed to hold during a pressing operation, nor will it hold a work load during positioning.

WARNING:

To help prevent personal injury, the ram and mounting plate MUST have maximum thread engagement to prevent the threads from stripping while the press is under full load.